

Date: Monday, 07/04/2008 2:30:12 PM  
User: Julie Lecocq

## **Process Sheet**

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FUEL PURGE CANISTER
<b>Job Number</b>	: 38446A	<b>Part Number</b>	: D32621
<b>Estimate Number</b>	: 10441	<b>Drawing Number</b>	: D3262 REV C
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 07/04/2008	<b>Drawing Revision</b>	: C
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:
<b>First Issue</b>	: / /	<b>Due Date</b>	: 30/04/2008
<b>Previous Run</b>	: 37369A	<b>Qty:</b>	6 Um: Each
<b>Written By</b>	:		
<b>Checked &amp; Approved By</b>	: <u>JDL</u> <u>08.4.06</u>		
<b>Comment</b>	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		
<b>Additional Product</b>			
Job Number:			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W 	
<b>Comment:</b> Qty.: 0.9406 f(s)/Unit Total: 3.7624 f(s) Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: <u>102019</u> <u>B 8-4-9</u> <span style="float: right;">(6)</span>			
2.0	BAND SAW	BAND SAW 	
<b>Comment:</b> BAND SAW Cut D3262-1 to length as per Dwg D3262 Identify as D3262-1 <u>B 8-4-9</u>			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>B 8-4-9</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-4-9</u>			
5.0	QC8	SECOND CHECK 	
<b>Comment:</b> SECOND CHECK <u>JDL</u> <u>08.05.09</u>			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 38446A

Part Number: D32621

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 164

AS 08/04/09

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-09

U

DART AEROSPACE LTD	Work Order:	38446A
Description: Tube	Part Number:	D3262-1
Inspection Dwg: D3262	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>JW</u>	Prototype Approval:	N/A
Date:	8-4-09	Date:	08-04-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue	KJ/JLM	
B	06.12.14	Dwg updated to Rev. C	KJ/JLM	E



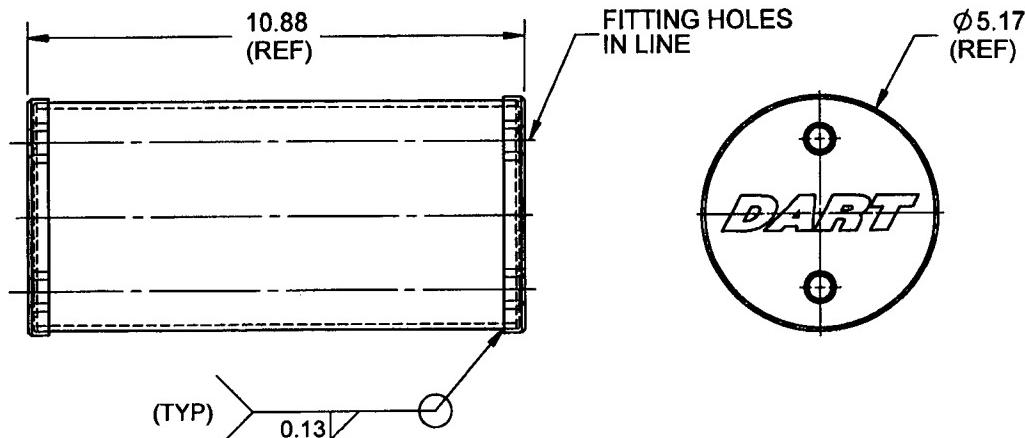
DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>HF</i>	DRAWING NO. D3262
DATE 06.08.31	TITLE FUEL PURGE CANISTER	REV. C SCALE 1:4 SHEET 1 OF 2

REV	DATE	DESCRIPTION
A	04.05.06	FIRST ISSUE
B	05.02.14	ADD PRESSURE TESTING OPTION
C	06.08.31	Ø5.165 WAS Ø5.190

RELEASED

06.09.19 *[Signature]*

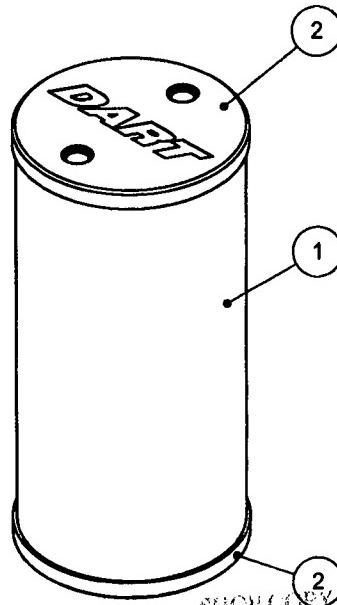


### D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART  
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



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WITHOUT NOTICE  
WORK ORDER  
*3844104*

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NO. *3844104*

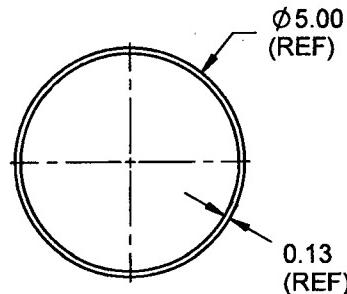
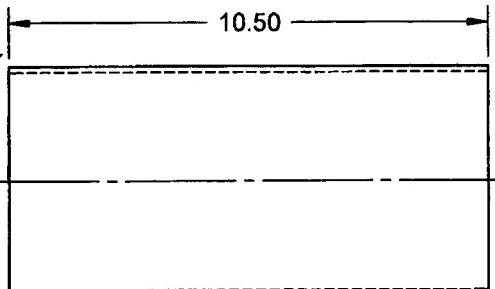
**DART**

DESIGN <i>PF</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. <b>D3262</b>
DATE 06.08.31	TITLE <b>FUEL PURGE CANISTER</b>	REV. C SHEET 2 OF 2 SCALE 1:4

SHOP COPY

RETURN TO  
ENGINEERING

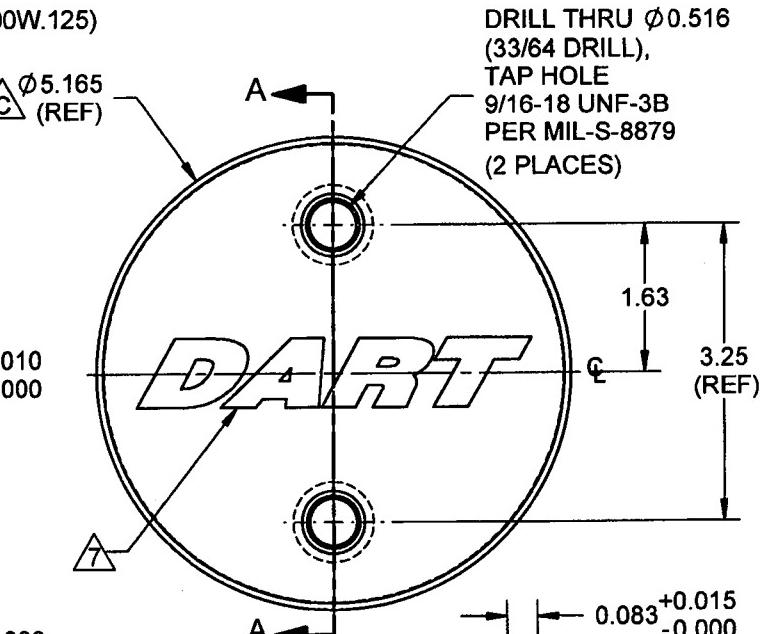
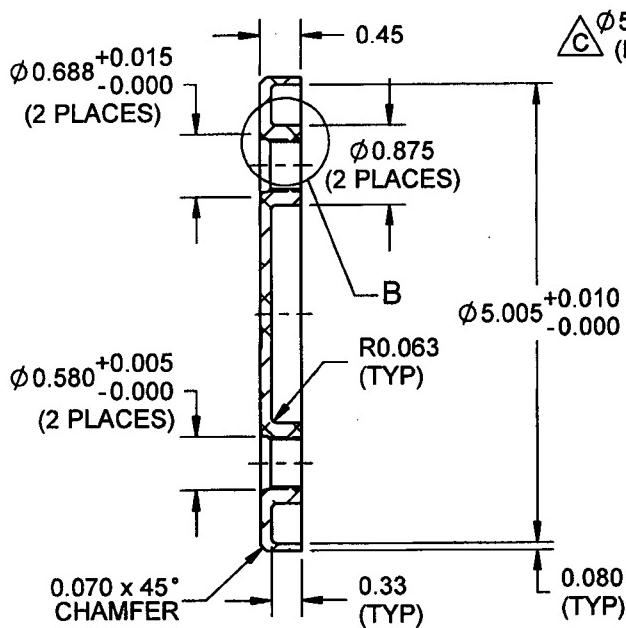
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WORK ORDER  
NO. 384461



RELEASED  
*JH*  
06.09.04

**D3262-1 TUBE**

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR  
QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T5.000W.125)



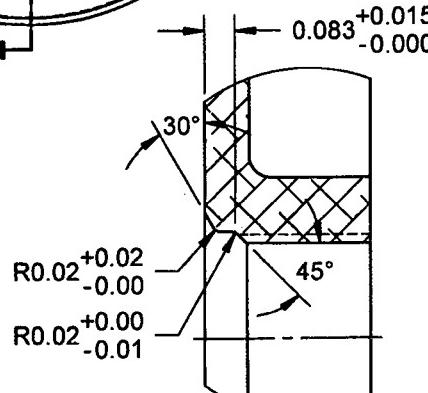
**SECTION A-A**  
SCALE 1 : 2

**D3262-3 CAP**

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



**DETAIL B**  
SCALE 2 : 1